



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5466-1
Job Sheet 187832



Part No: D5466-1

Job Qty: 4 ea

Part Name: Saddle, Fwd, In



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/17/18

Job Tracking No:

Due Date: 1/11/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: IPP Rev.A 17.07.12 New issue DP Verify DD IPP Rev.B 17.11.03 AS PER DWG REV.A DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	1/11/19	1/11/19	0.00	0.00	Start Up Machining-4		SBC 19/01/05
100	CNC Vertical Machining	4 pcs	1/11/19	1/11/19	0.00	3.45	HAAS1-1		SBC 19/01/06
120	QC	4 pcs	1/11/19	1/11/19	0.00	0.00	QC2 Machining-4		SBC 19/01/06
130	QC	4 pcs	1/11/19	1/11/19	0.00	0.00	QC8 Machining-4		SBC 19/01/07
140	HandFinish	4 pcs	1/11/19	1/11/19	0.00	0.51	HandFinish1		D.R. 19/01/08
150	SprayPaint	4 pcs	1/11/19	1/11/19	0.00	0.18	Spray Paint	Not required	
160	QC	4 pcs	1/11/19	1/11/19	0.00	0.00	QC14		
170	Packaging	4 pcs	1/11/19	1/11/19	0.00	0.00	Packaging3-2	ST389	JAN 23 2019
180	QC21-SA	4 Ea	1/11/19	1/11/19	0.00	0.00	QC21		JAN 23 2019

Part Op 100 - Program Batch No. S142092 Double check by: JMK 1-Machine Step No 1 per Folio FB551 and inspect per Descriptions: attached Dimension Sheets 2-Machine Step No 2 per Folio FB551 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FB551 and insp

150 - ***MASK HOLES PRIOR TO PRIME AND PAINT AS PER DWG NOTE 8*** 1-PRIME AS PER DWG AND QSI005 4.2.1.3.3 PRIMER BATCH: _____ 2-PAINT AS PER DWG AND QSI005 4.2.2.4 PAINT

BATCH: _____

163: Outsource - After 1004232 - 19-01-10
165: Receiving 4 X JAN 17 2019
167: QC 6

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-005	Saddle Billet	4 Ea (1 ea)	90-Start up Operation	S136639 S142091

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6101-005	4	16	0

Part Specifications

Specifications could not be found.

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____ Date : _____ Description		DISPOSITION ☐ Rework ☐ Skid tube ☐ Marking ☐ Large Fab ☐ Strap ☐ QIP Applied ☐ Use-as-is		DEPARTMENT/PROCESS Part: D5466 - 1 Job No: 187832 Serial No/Batch: S142092 Revision: A Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 01/05/19 Container No: S142092 DART AEROSPACE Uart Aerospace Ltd. 1270 Aberdeen Street Newbury, ON K8A 1K7 TEL: 513 832-8200 Email: sales@dartaero.com www.dartaerospace.com (Non-AW) ☐ Eng. Coord. ☐ /Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐ MRB (QSI042) Completed By Lead hand / Supervisor QC / QA Coordinator			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		FAULT CATEGORY Other/Details: _____					

DART AEROSPACE LTD		Work Order: 187 832
Description: Inner FWD SADDLE		Part Number: D5466-1
Inspection Dwg: D5466 Rev: A		Page 1 of 1

INSPECTION DIMENSION

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	438	443		438	438	438	438	
AB	1745	1755		1750	1750	1750	1750	
AC	3495	3505		3500	3500	3500	3500	
AD	7990	8010		7998	7998	7998	7998	
AE	490	510		500	500	501	500	
AF	257	262		258	258	258	258	
AG	375	380		375	375	375	375	
AH	490	510		501	500	500	500	
AI	1174	1184		1179	1179	1179	1179	
AJ	558	578		569	568	568	568	
AK	1174	1184		1179	1179	1179	1179	
AL	1490	1500		1495	1495	1495	1495	
AM	2495	2505		2500	2500	2500	2500	
AN	3869	3879		3874	3874	3874	3874	
AO	115	135		132	132	130	130	
AP	115	135		125	125	125	125	
AQ	240	260		252	252	252	252	
AR	115	135		126	125	126	125	
AS	230	250		240	240	241	241	
AT	115	135		129	130	130	132	
AU	353	373		366	366	366	364	
AV	053	073		058	056	058	056	
AW	615	635		625	624	623	623	
AX	1375	1395		1385	1385	1385	1385	
AY	1990	2010		2000	2000	2000	2000	
AZ	240	260		250	250	250	250	
AH	240	260		249	249	250	249	
Ensure that Ø " bore is perpendicular to " bore within "								
Accept/Reject								

Measured by: DAS	Checked by: [Signature]	QC Inspector:
Date: 57 19/01/06	Date: 19/01/07	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	15.04.27	New Issue	KJ	



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

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PURCHASE ORDER

PO042232



Supplier: ATE003-VC
Atelier Debosselage
358 Principale
Calumet
QC
J0V 1B0 Canada
Phone: 819 242 5633

PO No: PO042232
PO Date: 1/10/19
Due Date:
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	187832	D5466-1	Saddle, Fwd, In : Various STC's ISSUE P/O: _____ ***MASK HOLES PRIOR TO PRIME AND PAINT AS PER DWG NOTE 8*** 1-PRIME AS PER DWG AND QSI005 4.2.1.3.3 PRIMER BATCH: _____ 2-PAINT AS PER DWG AND QSI005 4.2.2.4 PAINT BATCH: _____ C OF C IS REQUIRED	Firmed	-		4 pcs	0 pcs	4 pcs	\$25.00/pcs	\$100.00
2	187833	D5467-1	Saddle, Fwd, Out : Various STC's ISSUE P/O: _____ ***MASK HOLES PRIOR TO PRIME AND PAINT AS PER DWG NOTE 8*** 1-PRIME AS PER DWG AND QSI005 4.2.1.3.3 PRIMER BATCH: _____ 2-PAINT AS PER DWG AND QSI005 4.2.2.4 PAINT BATCH: _____ C OF C IS REQUIRED	Firmed	-		4 pcs	0 pcs	4 pcs	\$25.00/pcs	\$100.00



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PURCHASE ORDER PO042232



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	187834	D5468-1	Saddle, Aft, Out : Various STC's ISSUE P/O: _____ ***MASK HOLES PRIOR TO PRIME AND PAINT AS PER DWG NOTE 8*** 1-PRIME AS PER DWG AND QSI005 4.2.1.3.3 PRIMER BATCH: _____ 2-PAINT AS PER DWG AND QSI005 4.2.2.4 PAINT BATCH: _____ C OF C IS REQUIRED	Firmed	-		4 pcs	0 pcs	4 pcs	\$25.00/pcs	\$100.00
4	187835	D5469-1	Saddle, Aft, In : Various STC's ISSUE P/O: _____ ***MASK HOLES PRIOR TO PRIME AND PAINT AS PER DWG NOTE 8*** 1-PRIME AS PER DWG AND QSI005 4.2.1.3.3 PRIMER BATCH: _____ 2-PAINT AS PER DWG AND QSI005 4.2.2.4 PAINT BATCH: _____ C OF C IS REQUIRED	Firmed	-		4 pcs	0 pcs	4 pcs	\$25.00/pcs	\$100.00
Grand Total:											\$400.00

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.